

Thursday, 05/02/2009 8:43:20 AM

Lawson

Process Sheet

Job Number : CU-DAR001 Dart Helicopters Services
 Estimate Number : 45497
 P.O. Number :
 This Issue : 05/02/2009 S.O. No. :
 Prsht Rev. : NC
 First Issue : / / Type : SMALL /MED FAB
 Previous Run : 44671
 Written By :
 Checked & Approved By : JWO 090205
 Comment : Est Rev:A New Issue 07-07-20 JLM Verified By:EC
 Est Rev:B ECN 1050 rev.b as per dwg 08-01-10 DD

Drawing Name : COVER
 Part Number : D36414
 Drawing Number : D3641 REV B
 Project Number : N/A
 Drawing Revision : B
 Material :
 Due Date : 11/02/2009 Qty: 6 Urm: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6S032 6061-T6 Sheet 0.032"



MAT NOT PULLER



Comment: Qty.: 0.8244 sf(s)/Unit Total: 4.9461 sf(s)

M6061-T6 .032" THK sheet

Batch: 10063

~~WRONG MAT~~ 5052 ON DRAWING SERP.

IB 9-4-4

108724

POD

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3641

Dwg Rev: B

Prog Rev: B

IB 9-4-4

2-Deburr if necessary

IB 9-4-4

9 16

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



IB 9-4-4



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

8 09/04/13 16

5.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

Form as per Dwg D3641-1

SB 09/04/22

16

W/O: 45497		ESTIMATE: 12963		WORK ORDER CHANGES				
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
9.1.23	1	Est. wrong change mat'l per drug permanent change						

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 05/02/2009 8:43:20 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: COVER

Job Number: 45497

Part Number: D36414

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 02/04/22 (16)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

9/1 09-0 4-22 (16)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BL 02 Oct-22 (16)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N using a permanent fine point marker, then Stock

Location: 57260

9/4/22 (14)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/04/23

Job Completion



u 9.04.23

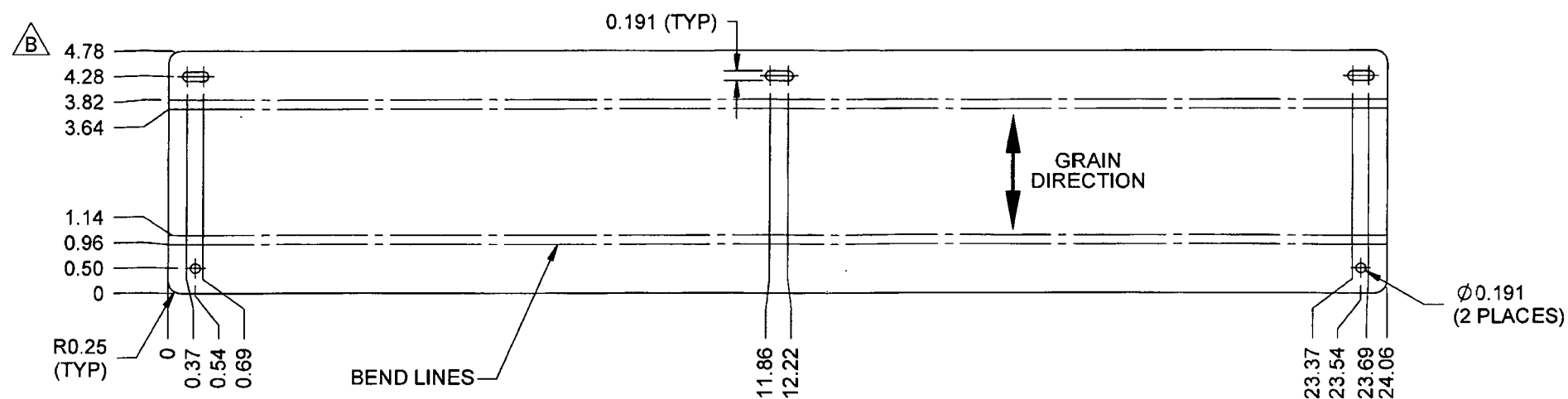
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

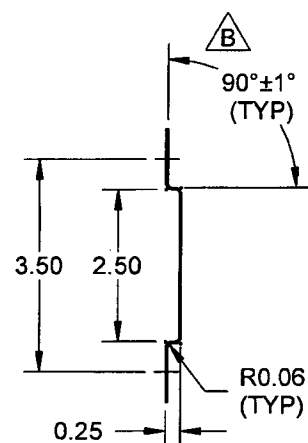
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3641-1F FLAT PATTERN



**D3641-1 COVER
(REPLACES GENEVA P/N G10606-3/-6)**

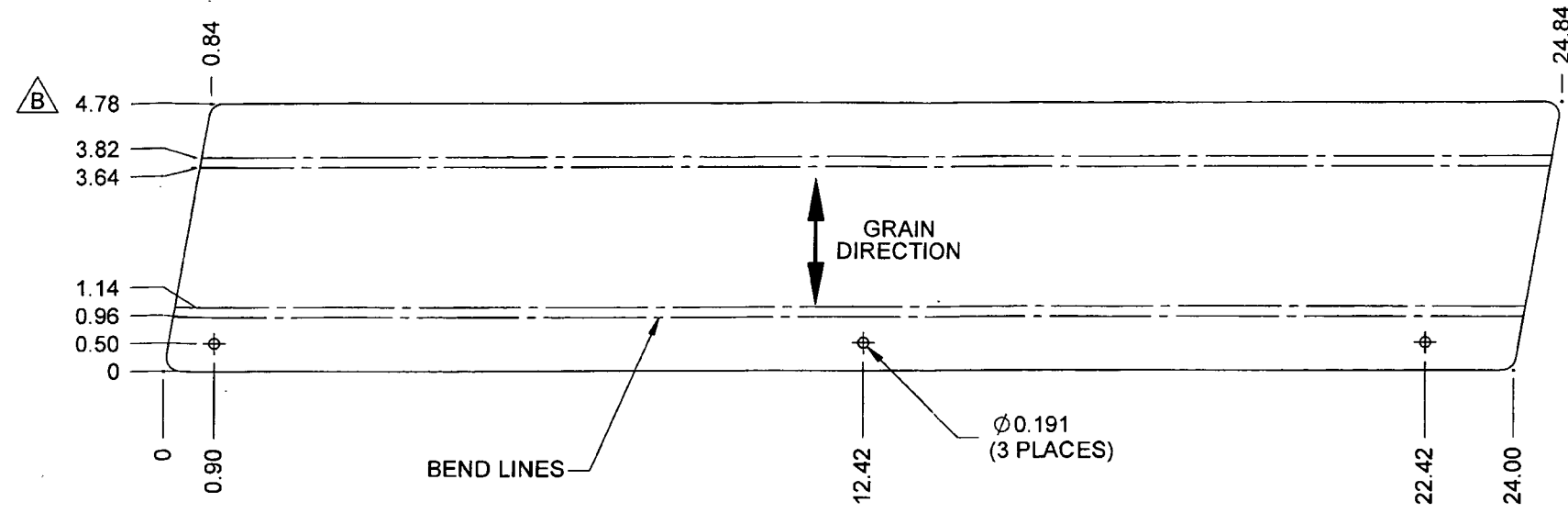
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 45497

RELEASED
07.11.14

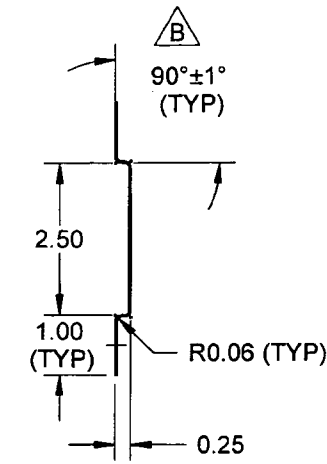
- NOTES:**
- 1) MATERIAL: 5052-H32 ALUMINUM 0.032 THICK PER QQ-A-250/8 OR AMS 4016 (REF DART SPEC M5052H32S.032)
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3641-1" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 0.35 lbs

B	UPDATE PROFILE TO MATCH TOOLING; GENERAL UPDATE	LE	07.10.16
A	NEW ISSUE; REPLACES G10606	LE	07.07.27
REV.	DESCRIPTION	BY	DATE
DESIGN	TS LE RA [Signature] RA [Signature]	DART AEROSPACE USA, INC.	
DRAWN		PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. I
MFG. APPR.			
APPROVED		D3641	SHEET 1 OF
DE APPR.		TITLE	SCALE
DATE	COVER	1:	
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8 7 6 5 4 3 2 1



D3641-3F FLAT PATTERN



D3641-3 COVER
(REPLACES GENEVA P/N G10606-5)
D3641-4 OPPOSITE
(REPLACES GENEVA P/N G10606-4)

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WITHOUT NOTICE
WORK ORDER
NO. 4549

RELEASED
07.11.14

- NOTES:
- 1) MATERIAL: 5052-H32 ALUMINUM 0.032 THICK PER QQ-A-250/8 OR AMS 4016 (REF DART SPEC M5052H32S.032)
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3641-3/-4" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 0.36 lbs

DESIGN	TS	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	LE		
CHECKED	PH	DRAWING NO.	REV. B
MFG. APPR.	PH	D3641	SHEET 2 OF 2
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